**G Code Programming:**

**g00 rapid positioning**

**g01 linear interpolation**

**g02 circular / helical interpolation (clockwise)**

**g03 circular / helical interpolation (c-clockwise)**

**g04 dwell**

**g10 coordinate system origin setting**

**g17 xy plane selection**

**g18 xz plane seledtion**

**g19 yz plane selection**

**g20 inch system selection**

**g21 millimeter system selection**

**g40 cancel cutter diameter compensation**

**g41 start cutter diameter compensation left**

**g42 start cutter diameter compensation right**

**g90 absolute distance mode**

**g91 incremental distance mode**